

Date: Tuesday, 08/04/2008 4:57:37 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	412 X-TUBE INST, LOW NARROW AFT
Job Number :	38489		
Estimate Number :	12817		
P.O. Number :		Part Number :	D412664205
This Issue :	08/04/2008	Drawing Number :	D412-664 -245 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	C
Previous Run :	38488	Material :	
Written By :		Due Date :	30/05/2008
Checked & Approved By :	<u>DP 08-409</u>	Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 07-04-05 JLM		

Additional Product

Job Number:



SCRAP

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-205 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D412664205TRN	CROSSTUBE TURNING DETAIL
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B39072

DP 8-7-15

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP 8-7-15

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

6.0	D36061
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF




Batch: _____

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-13	4.0	Tube is over bend on 1 side. - Bend development.	 08/09/09	- Scrap: no replace. - change to bend development			 08/09/09	 08-08-13

NOTE: Date & initial all entries

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Job Number: 38489

Part Number: D412664205

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D412-664-245 using DT8972.

2-Drill pilot holes in tube as per Dwg D412-664-245

3-Ream hole to finish size in tube as per Dwg D412-664-245

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

OUTSIDE SERV.10

OUTSIDE SERVICES skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

Handwritten signature: LVP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 412 X-TUBE INST,LOW NARROW AFT

Job Number: 38489

Part Number: D412664205

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D412-6647-245. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: _____

15.0

CR3212407

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch: _____

16.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

SCVAD

17.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

18.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Chafing Shield

Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

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Drawing Name: 412 X-TUBE INST,LOW NARROW AFT

Job Number: 38489

Part Number: D412664205

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.0536 sf(s)

Rubber Cushion

Cut to .630" X 5.7" X 2PCS

Batch: _____

20.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support _____

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

2 X D2856-600-1009

Batch: _____

22.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp _____

23.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: _____

24.0

CROSSTUBES

CROSSTUBES/RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-245

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST,LOW NARROW AFT

Job Number: 38489

Part Number: D412664205

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install Chaffing Shields

3-Instal support with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application: _____

Batch: _____

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) ;

Bolt

Batch: _____

28.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

29.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: _____

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

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Drawing Name: 412 X-TUBE INST,LOW NARROW AFT

Job Number: 38489

Part Number: D412664205

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-105

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

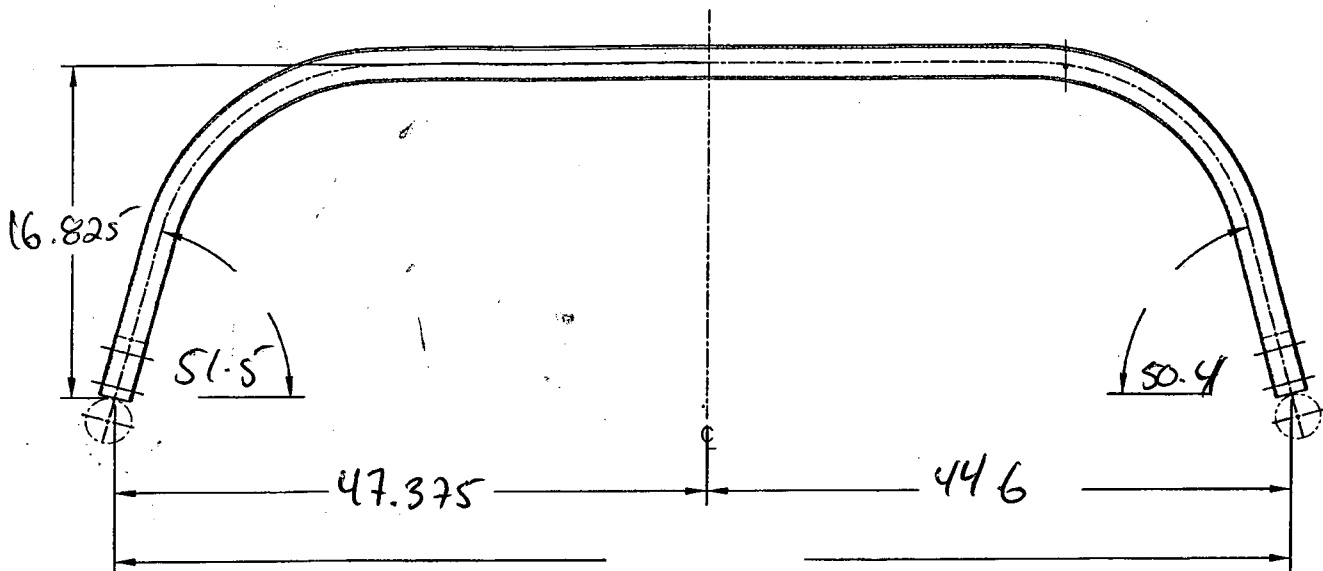
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38489
Description: Crosstube Low Narrow Aft (412)		Part Number:	D412-664-205
Inspection Dwg: D412-664-245 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	16.69	16.95
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments
Tube is scrap. Over bend on one side.

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM	

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-245	REV. C SHEET 1 OF 3
DATE 07.03.29		TITLE CROSSTUBE ASS'Y (412 LOW-N AFT) NTS	
A	06.12.01	NEW ISSUE	
B	07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION	
C	07.03.29	CHG RIVET AND RUBBER CUSHION	

RELEASED07.04.24 *[Signature]***PARTS LIST:**

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3606-1	CUFF
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

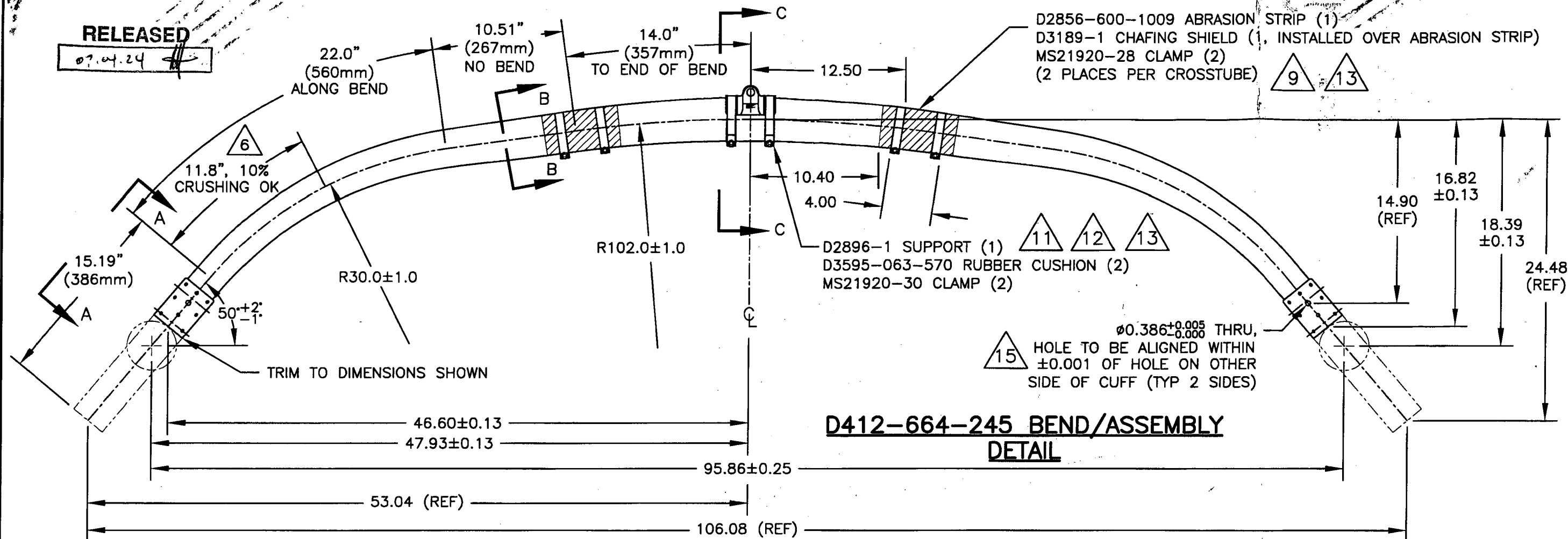
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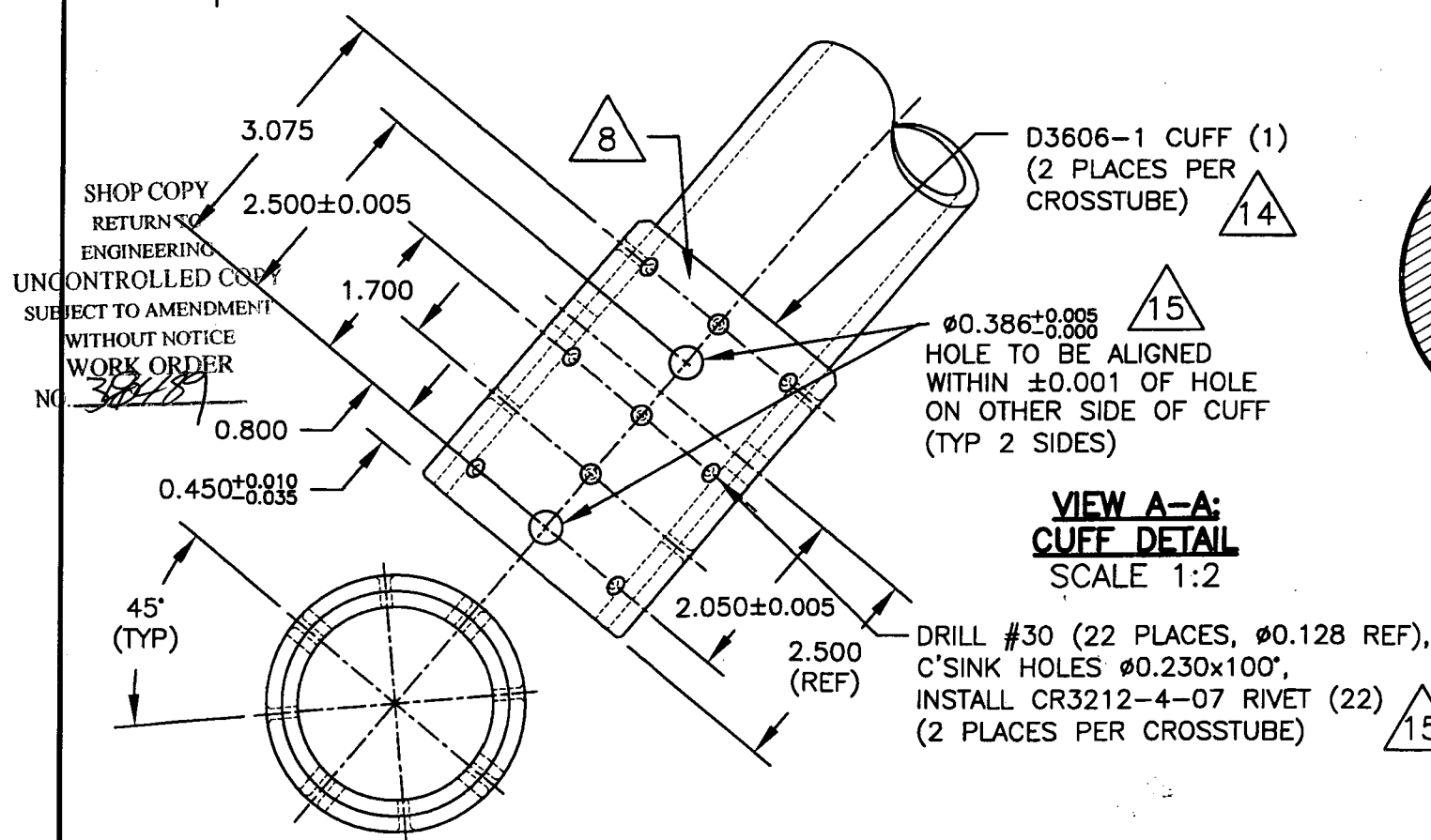
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NO. 384874

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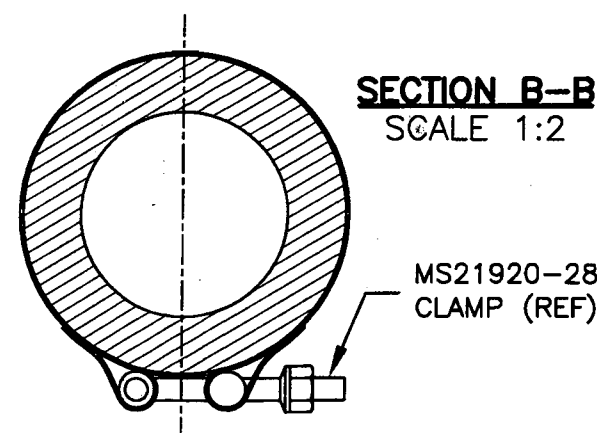
07.04.24



D412-664-245 BEND/ASSEMBLY DETAIL



VIEW A-A: CUFF DETAIL SCALE 1:2



SECTION B-B SCALE 1:2

APPLY MAGNOBOND
BETWEEN D2896-1 AND
THE CROSSTUBE



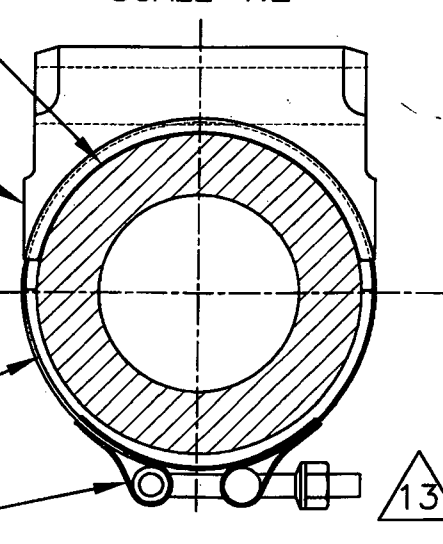
D2896-1
SUPPORT
(REF)

D3595-063-570
RUBBER CUSHION
(UNDER CLAMP, REF)



MS21920-30
CLAMP (REF)

SECTION C-C SCALE 1:2



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DESIGN

07

DRAWN BY

07

CHECKED

07

APPROVED

07

DATE

07.03.29

DART

DART AEROSPACE LTD.
HAMMERSBURY, ONTARIO, CANADA

DRAWING NO.
D412-664-245

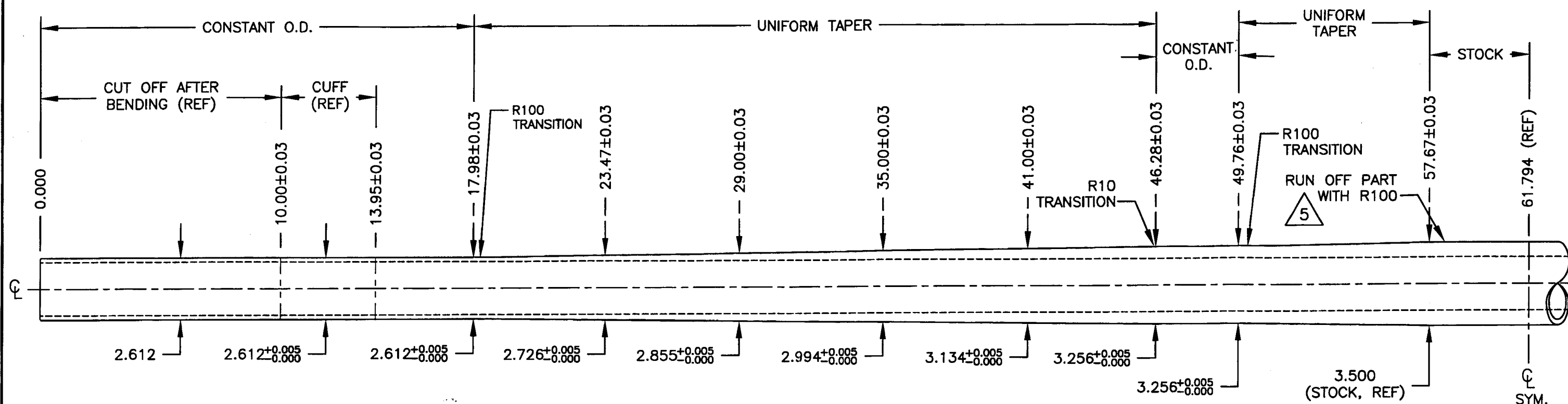
REV. C

TITLE

CROSSTUBE (412 LOW-NARROW AFT)

SHEET 2 OF 3

SCALE
1:8







D412-664-245 MACHINING DETAIL

RELEASED

07.04.19

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	CHECKED 	APPROVED 	DRAWING NO. D412-664-245	REV. C SHEET 3 OF 3
	DATE 07.03.29		TITLE CROSSTUBE (412 LOW-NARROW AFT) 1:4	

